



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3296-1
Job Sheet 172815



Part No: D3296-1

Job Qty: 8 ea

Part Name: Door Panel



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/22/18

Job Tracking No:

Due Date: 3/12/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP C 05.10.14 Added step 14 KJ/EC IPP Rev:D Now on Waterjet 06-11-02 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	8 Ea		3/10/18	0.00	0.00	Start Up Waterjet		du 18/03/06
100	Waterjet	8 pcs		3/10/18	0.03	0.83	Waterjet1		du 18/03/06
120	QC	8 pcs		3/10/18	0.00	0.00	QC8		38
140	HandFinish	8 pcs		3/12/18	0.00	0.42	HandFinish1		SA PAS-89
150	QC	8 pcs		3/12/18	0.00	0.00	QC7-2		11
160	Packaging	8 pcs		3/12/18	0.00	0.00	Packaging3	5/494	9-89
170	QC21-SA	8 Ea		3/12/18	0.00	0.00	QC21		21

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.063	2024-T3 .063 Sheet	5.2768 sf (.6596 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.063	5	167	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Door Panel	5.080inches ± 0.030	5.110 5.050		
2	Door Panel	0.060inches ± 0.030	0.090 0.030		
3	Door Panel	0.300inches ± 0.010	0.310 0.290		
4	Door Panel	0.128inches + 0.005 - 0.000	0.133 0.128		
5	Door Panel	16.400inches ± 0.005	16.405 16.395		
6	Door Panel	0.300inches ± 0.010	0.310 0.290		
7	Door Panel	13.400inches + 0.005 - 0.030	13.405 13.370		
8	Door Panel	17.000inches ± 0.030	17.030		

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	Skid-tube ☐ Machining ☐ Thermoforming ☐ Large ☐	Against DEPARTMENT/PROCESS Cross tube ☐ Small Fah ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Core/Packaging Supplier ☐ Engineering Quality ☐ Other ☐	Date : _____ Step #: _____	MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Description Work Order Deviation:					

Dart Aerospace Ltd.
 1270 Aberdeen Street, Unit 1K7
 K1A 0K6
 CANADA
 TEL.: 1 813 632-6200
 Email: sales@dartaero.com
 www.dartaero.com

Date: 03/06/18

Container No: S048255
 Part: D3296-1
 Job No: 172815
 Serial No/ Batch: S048255
 Revision: _____
 Inspector: _____

Root Cause			
Environment	☐	No Re-verification	☐
Design	☐	Operator	☐
Doc/Data	☐	Offset/Setup	☐
Equip/Tooling	☐	Supplier	☐
Handling/Pre	☐	Training	☐
Material	☐	Use for Testing	☐
Internal Transport	☐	Poor Information	☐
Tribal Knowledge	☐	Rushing	☐
LOA	☐	Product Improvement	☐
Substation	☐	Process Improvement	☐
Past Expiry Date	☐	Manufacturing Process	☐
Misidentified	☐	Past Due	☐

OTHER : _____

			16.970
9	Door Panel	14.180inches $\pm$ 0.030	14.210 14.150
10	Door Panel	0.300inches $\pm$ 0.010	0.310 0.290
11	Door Panel	0.063inches $\pm$ 0.010	0.073 0.053

Plex 2/22/18 6:13 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							